

Work Order ID 120017

June-02-14 11:05:33 AM

120017

Page 1

Item ID: D212-664-101

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fwd Crosstube - High

Start Date: 6/02/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/02/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLS Date: 14-06-02 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D212-664-141	E							MLS 14-07-14	
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels as per PPP D212-664-101 CHG006								
110	Pick Kit	0.00							
110	Packaging								
Packaging	Memo	0.00							
Packaging									
120		0.00							
120	BENDING MACHINE - CROSSTUBES								
CNC Bend 2	Memo	0.00							
CNC Alpha 160 Bender	Bend tube as per Dwg D212-664-141 using CNC bender program 212-fw and Folio D212-664-101								

JUL 17 2014

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JW 14-06-26

JW 14-06-26

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Item ID: D212-664-101

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fwd Crosstube - High

Start Date: 6/02/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 6/02/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC15- Crosstube Dimensional Check	0.00							
130									
QC	Memo	0.00							
Quality Control									
140		0.00							
140	Crosstubes								
Crosstubes	Memo	0.00							
Crosstubes	1-Drill pilot holes in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549,using drill table DT8577,set-up towers in hole #7 as per QSI 10								
	2-Ream hole to finish size in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549.Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.								
	3-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-141								
	4-*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141								

DL 14-07-01

BC 14-07-02

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Item ID: D212-664-101

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Fwd Crosstube - High

Stop ***NS2***

Start Date: 6/02/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/02/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QCS- Inspect part completeness to step on W/O	0.00	<i>EB</i>	DAS					
150			<i>14/07/03</i>	27		<i>①</i>			
QC	Memo	0.00		9-89					
Quality Control	*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***								
160		0.00							
160									
HandFXtube	Memo	0.00							
Hand Finishing Crosstubes	*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***								
	1- CLEAN CROSSTUBE WITH WASH'N WIPE								
170	Outsource process - NDT per QSI038 4.1	0.00							
170									
Outsource2	Memo	0.00							
Outsource process - NDT	*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***								
	Liquid Penetrant Inspection as per QSI 038								
	Issue P/O: <i>24902</i>								
	LPI as per ASTM 1417 Level 2								
	Attach copy of NDT results to work order								

1 0 0 18
14-7-8

CL 14/07/08 ①

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1- PRESSURE WASH AND THEN USE WASH'N WIPE TO CLEAN CROSSTUBE BEFORE CHEMICAL CONVERSION

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BS

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***** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE *****

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Item ID: D212-664-101 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Fwd Crosstube - High
 Start Date: 6/02/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 6/02/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Spray Painting per QSI005 4.2	0.00							
200	SprayPaint	0.00							
Spray Painting	Memo								
	*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***								

1-Prime inside and outside crosstube as per QSI 005 4.2

PRIME BATCH: 129328

Start Time: 3:00

Finish Time: 3:30

MASK UNDERSIDE OF CROSSTUBE AS SHOWN ON DWG

2-Paint outside crosstube with White Imron as per QSI 005 4.2

PAINT BATCH: 129597

Start Time: 6:20

Finish Time: 8:00

3- Remove masking and apply matte clear coat as per dwg

CLEAR BATCH: 129174

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1 _____ CL 14-07-10

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Item ID: D212-664-101 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd Crosstube - High
Start Date: 6/02/14 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/02/14 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 *210* QC Quality Control	QC14- Inspect Spray Paint Memo Then, Wrap in plastic bag to protect from scratches	0.00 0.00		DAS 27 9-83 147117					
220 *220* Crosstubes Crosstubes	Crosstubes Memo 1- Abrade mating surfaces of support and crosstube with 180 grit sandpaper, clean the area with MEK or equivalent as per dwg 2- Install supports with Proseal 890 per D212-664-141 and QSI 015 A/R Proseal 890 Batch: <u>128638</u> EXP: <u>10/14</u> PROSEAL CURE TIME 72 HOURS: Start: <u>14-07-10</u> Finish: <u>14-07-13</u> 3- Install clamps with rubber cushion (ENSURE CLAMPS ARE INSTALL ON TOP SIDE OF CROSSTUBE) using DT9565 as per Dwg D212-664-141. ***Torque all clamps to 80-100 IN-LBS.***	0.00 0.00				1			CR 14-07-10

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Item ID: D212-664-101

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Fwd Crosstube - High

Stop ***NS2***

Start Date: 6/02/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/02/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230	QC5- Inspect part completeness to step on W/O	0.00							
230									
QC	Memo	0.00							
Quality Control	***RE-CHECK TORCQUE ON CLAMP AFTER PROSEAL HAS CURED FOR 72HOURS AS PER DWG.***								

240	Pick Kit	0.00							
240									
Packaging	Memo	0.00							
Packaging									

250	QC4- 100% Inspect kits for completeness	0.00							
250									
QC	Memo	0.00							
Quality Control									

DAS 31 9-89	1x	14-07-17
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DAS
26
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Quality Control

1 ~~S~~ S 14-07-17

MLJ 14-07-18

MLJ 1407-18

Picklist Print

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Parent Item: D212-664-101

D212-664-101

Parent Item Name: Fwd Crosstube - High

Start Date: 6/02/14

Required Date: 6/02/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:E04.02.16ReformatKJ/DS
IPP Rev:F 06-03-29 Remove Coments on Pick List JLM
IPP Rev:G 07-04-30 As per Rev C JLM IPP Rev:H
11.04.26 inspection strip ecn 11-549 EC verf by:DD IPP REV:I 14.05.27
AS PER ECN 14-570 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D212-664-101TRN		Manufactured	No			110	Each	4.0000	1	1			
D212-664-101TRN													
Crosstube Turning Detail													

Location

Loc Qty

Loc Code

LG

4

116468

1

116469

1

119586

1

119867

1

D3595-063-450

Manufactured No

230

Each

296.0000

4

4

D3595-063-450

Rubber Cushion

Location

Loc Qty

Loc Code

FG

15

88422

5

94274

10

LG

100

115083

100

LG050

4

118828

4

LG051

177

109526

2

115271

4

116587

20

117650

151

4

Picklist Print

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Work Order ID: 120017

120017

Parent Item: D212-664-101

D212-664-101

Parent Item Name: Fwd Crosstube - High

Start Date: 6/02/14

Required Date: 6/02/14

Start Qty: 1.00

Required Qty: 1.00

MS21920-25

Purchased

No

220

Each

43.0000

4

4

MS21920-25

Clamp

**

CR 17-07-10

4 + 1 scrap AS 14-7-12

Location

Loc Qty

Loc Code

FG

2

120920

2

LG

1

M128994

1

LG050

37

M128012

1

M128701

25

M128718

11

Return2014

3

128012

3

D2893-1

Manufactured

No

220

Each

24.0000

2

2

D2893-1

Support

**

CR 19-07-0

2

Location

Loc Qty

Loc Code

FG

2

87289

2

LG052

22

102854

1

110724

1

117838

4

119130

16

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Shop Packet Print

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Picklist Print

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Work Order ID: 120017

120017

Parent Item: D212-664-101

D212-664-101

Parent Item Name: Fwd Crosstube - High

Start Date: 6/02/14

Required Date: 6/02/14

Start Qty: 1.00

Required Qty: 1.00

D3428-1

Manufactured No

240

Each

15.0000

1

D3428-1

Placard

DAS
31
9-89

Location

Loc Qty

Loc Code

ST042

15

107703

1

112604

12

115887

2

**

1

B119695

DAS
26
9-89

AN6-35A

Purchased No

240

Each

54.0000

4

AN6-35A

BOLT

DAS
31
9-89

Location

Loc Qty

Loc Code

ST340

54

m128300

4

m128324

50

**

4

m129507

DAS
26
9-89

AN6-36A

Purchased No

240

Each

113.0000

4

AN6-36A

Bolt

DAS
31
9-89

Location

Loc Qty

Loc Code

ST340

4

M126474

2

m127124

2

ST504

109

m127363

34

M128403

75

**

4

14-7-17

DAS
26
9-89

4X

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Picklist Print

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Work Order ID: 120017

120017

Parent Item: D212-664-101

D212-664-101

Parent Item Name: Fwd Crosstube - High

Start Date: 6/02/14

Required Date: 6/02/14

Start Qty: 1.00

Required Qty: 1.00

MS21042L6

Purchased

No

240

Each

301.0000

6

6

MS21042L6

Nut

**

DAS 06
26 9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

ST314

301

m127831

23

m128635

278

3x m 129499.

3x

DAS 06
9-89

NAS1149D0663J

Purchased

No

240

Each

1,977.000

18

18

NAS1149D0663J

Washer

**

147-17

DAS 26
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

ST294

7

123265

4

M126284

3

ST510a

1970

M126334

699

M127813

35

M127916

236

M128818

1000

18x

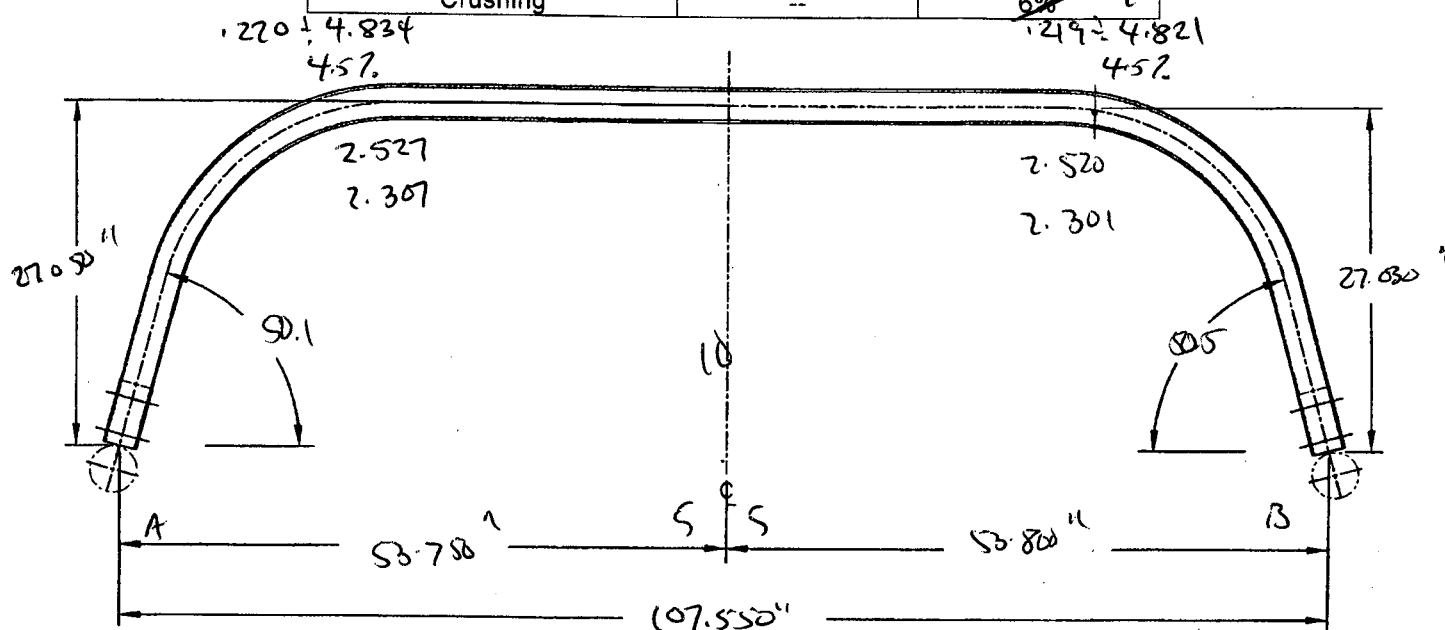
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Shop Packet Print

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DART AEROSPACE LTD		Work Order:	120017
Description: Crosstube High Fwd (205/212/412)		Part Number:	D212-664-101
Inspection Dwg: D212-664-141	Rev: <i>DE</i>	Page 1 of 1	

Required Dimension	Min	Max
Height	26.79	27.05
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.7
Bending Passes	3	--
Crushing	--	6%



	Side A	middle	Side B
Bending Passes	5	10	5
Crushing	4.57%		4.57%
Comments			
Side A = 4.57% crush @ 5 passes.			
Middle = 10 passes.			
Side B = 4.57% crush @ 5 passes.			

QC15 Inspection	DAS
Date	16 9-89 14/04/77

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	08.04.21	Dwg Rev updated	KJ/JM	
C	10.04.01	Dwg Rev updated	KJ	
D	12.04.16	Added bending, crushing dimensions	KJ	

Item	Qty -141	Qty -141B	Qty -141F	Part Number	Description
1	X			D212-664-141	CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD)
2		X		D212-664-141B	CROSSTUBE ASSEMBLY (214 HIGH FWD)
3			X	D212-664-141F	CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD) (ANODIZED)
4	1	1	1	D6005-128	CROSSTUBE
5	2		2	D2893-1	SUPPORT
6	4	4	4	D3595-063-450	RUBBER CUSHION
7		2		D5017-1	SUPPORT
8	4	4	4	MS21920-25	CLAMP (OR MS21920-26)
9	A/R	A/R	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D6005-128
FINISHED LENGTH = 128.514±0.020
- FINISH -141 & -141B: a) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
b) PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
c) MASK UNDERSIDE OF CROSSTUBE AS SHOWN (ZN C6-2 / C6-3, HATCHED AREA)
d) PAINT OUTSIDE PER DART QSI 005 4.2
e) REMOVE MASKING AND APPLY MATTE CLEAR COAT

- FINISH -141F: a) ANODIZE PER MIL-A-8625, TYPE II, CLASS 1.
b) ALODINE (DO NOT ETCH) PER QSI 005 4.1.2
c) PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
d) MASK UNDERSIDE OF CROSSTUBE AS SHOWN (ZN C6-2 / C6-3, HATCHED AREA)
e) PAINT OUTSIDE PER DART QSI 005 4.2
f) REMOVE MASKING AND APPLY MATTE CLEAR COAT

***NOTE:** BETWEEN FINISHING OPERATIONS EXTREME CARE MUST BE TAKEN NOT TO CONTAMINATE OR DAMAGE FINISHED SURFACES.

- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS
- WEIGHT: D212-664-141/-141B/-141F = 33.6 lbs
- PART IS SYMMETRIC ABOUT CENTERLINE.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

MACHINING

- RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.

BENDING

- BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 7.2% (BASED ON O.D.) IN LOWER HALF OF R35.5 BEND AND 6% (BASED ON O.D.) ON REMAINING TUBE.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.

ASSEMBLY

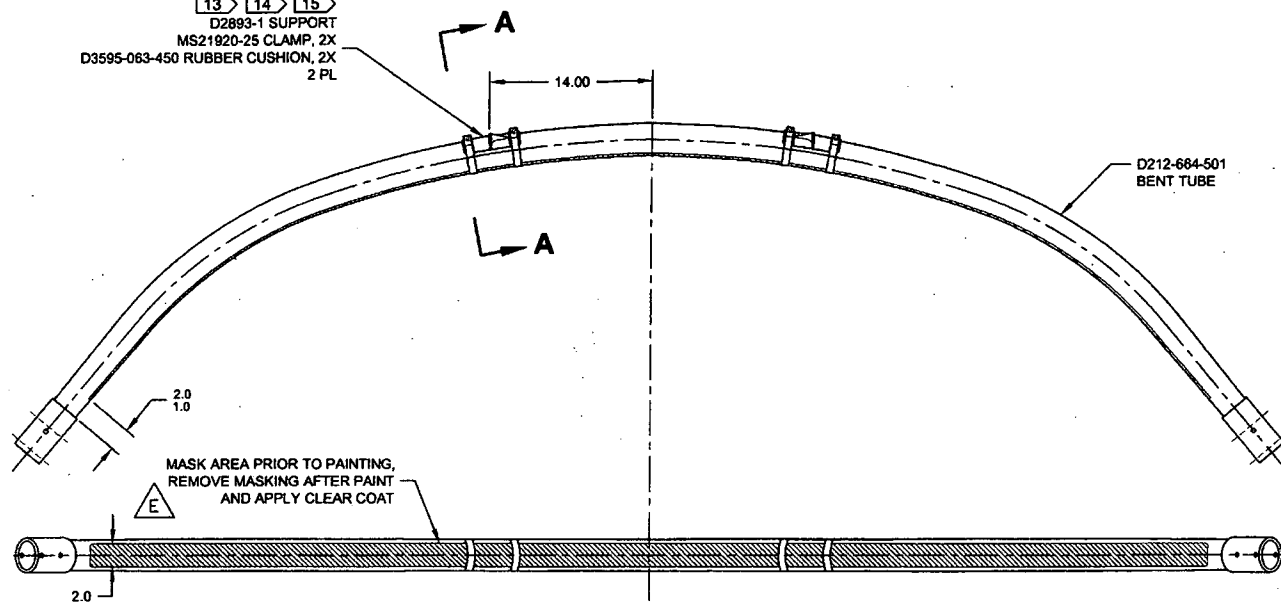
- TO INSTALL D2893-1 / D5017-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE ON TOP SIDE OF CROSSTUBE.
- TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 120017 MW
140602

RELEASED
2014-05-26
WD

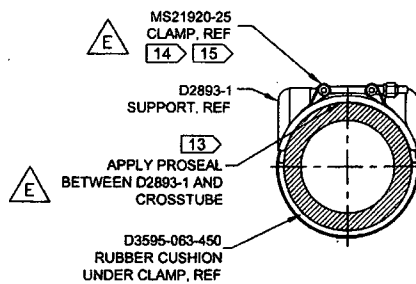
E	ADD -141F. D5017-1 WAS D2893-1 (-141B), PROSEAL WAS MAGNOBOND, NOTE 2: ADD INSPECTION WINDOW. NOTE 11: ALLOW 7.2% CRUSH. NOTE 15: ADD 72HR CURE AND RETORQUE FOR PROSEAL, ADD SHEET 3. CLAMPS REVERSED TO PREVENT CHAFING (B7-2, B7-3), BEND HEIGHT TOL. NOW 0.25 WAS 0.13 (C1-3), INCORP. DEO D-1/-2/-3	CP	14.04.01
D	REFORMAT/REVISE GENERAL NOTES/PART LIST; REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; ADD -141B (ZN B4-2, D4-2); REMOVED REF & ADD TOLERANCES (ZN B4-3, C6-3, C8-3 & B6-3); RELOCATED FLAG #6 PER PAR 08-046 (ZN A5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4	RF	09.09.30
C	REMOVE -351 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	PH	07.03.08
B	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	CP	00.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	DP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DP	DRAWING NO. D212-664-141	REV. E SHEET 1 OF 5
CHECKED	DW	TITLE	SCALE
MFG. APPR.	JD	XTUBE ASS'Y (205/212/412 HI FWD)	NTS
APPROVED	JD	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DE APPR.	JD	DATE	14.04.01

13 14 15
D2893-1 SUPPORT
MS21920-25 CLAMP, 2X
D3595-063-450 RUBBER CUSHION, 2X
2 PL



SYM

D212-664-141/-141F
ASSEMBLY DETAIL



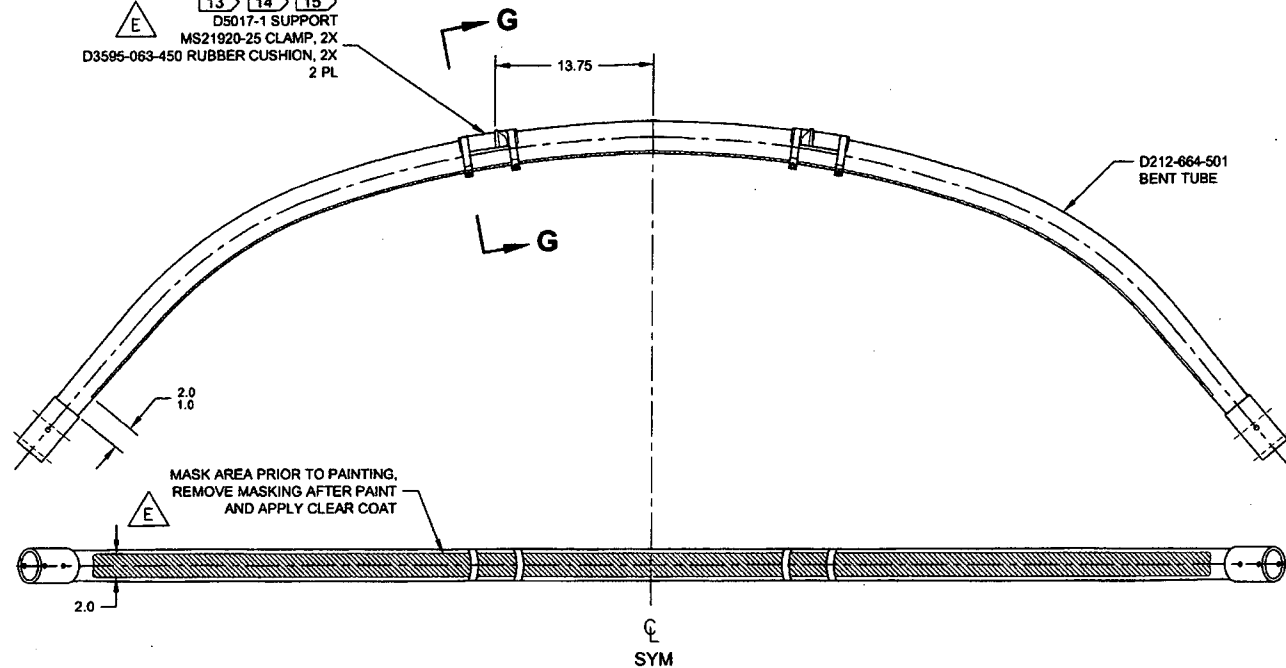
SECTION A-A
SCALE 4X

RELEASED
2014-05-26

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		D212-664-141
APPROVED		TITLE
DE APPR.		XTUBE ASS'Y (205/212/412 HI FWD)
DATE	14.04.01	SCALE
		NTS

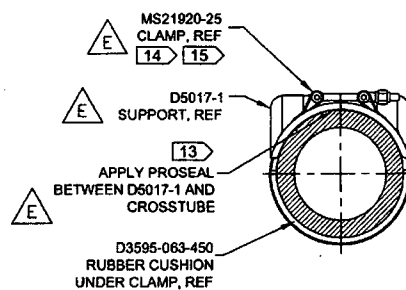
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13 14 15
 D5017-1 SUPPORT
 MS21920-25 CLAMP, 2X
 D3595-063-450 RUBBER CUSHION, 2X
 2 PL



D212-664-501
BENT TUBE

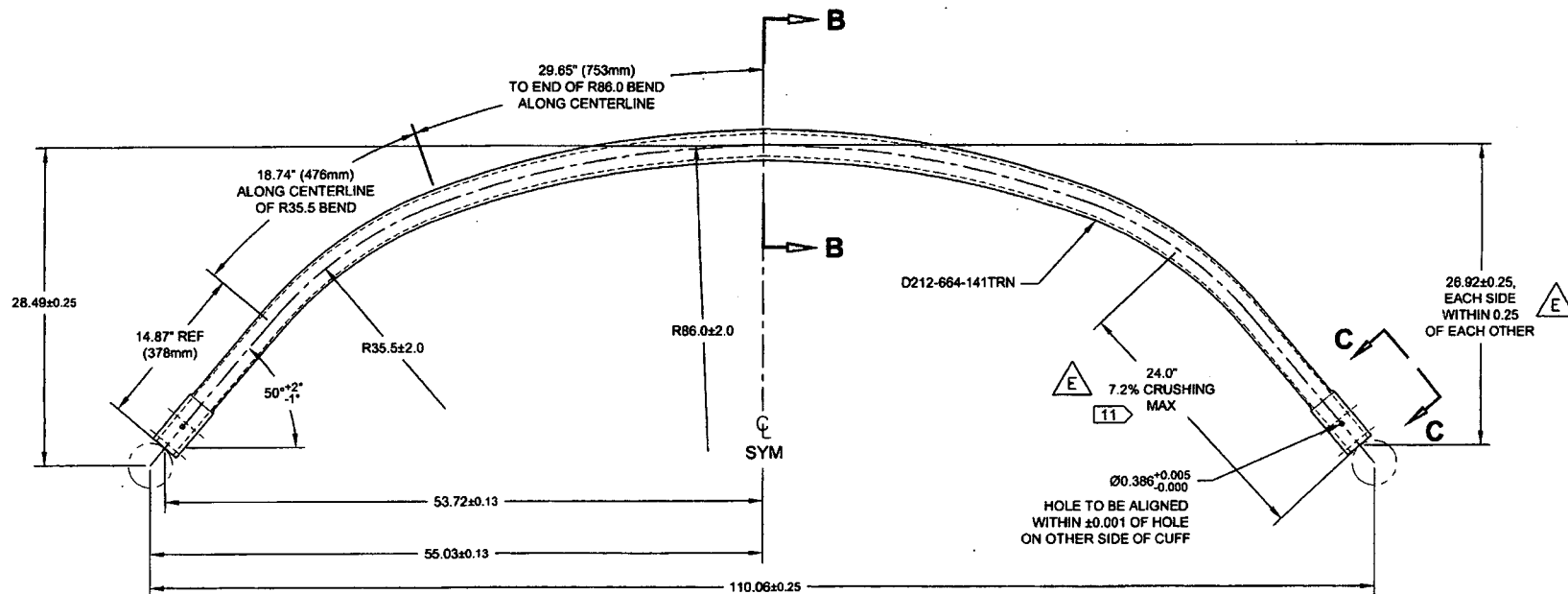
D212-664-141B
 ASSEMBLY DETAIL



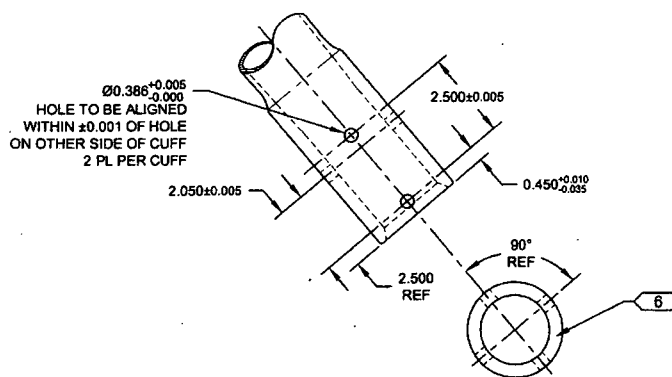
SECTION G-G
 SCALE 4X

RELEASED
 2014-05-26

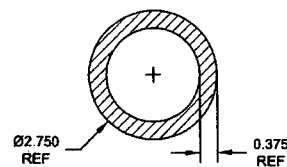
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	DLJ	DRAWING NO.	REV. E
MFG. APPR.		D212-664-141	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		XTUBE ASS'Y (205/212/412 HI FWD)	NTS
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D212-664-501
BENDING AND DRILLING DETAIL 11



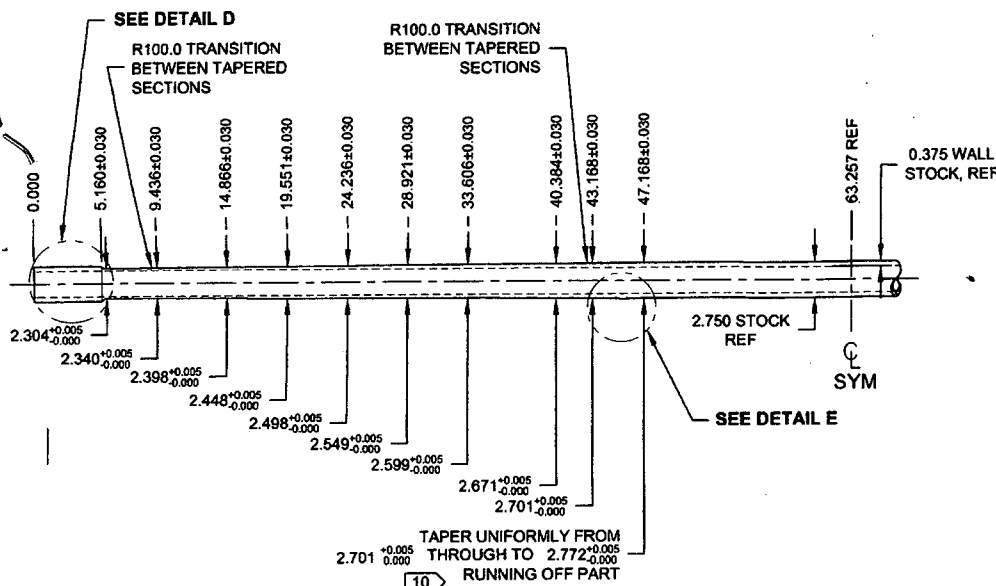
VIEW C-C: CUFF DETAIL
SCALE 3X



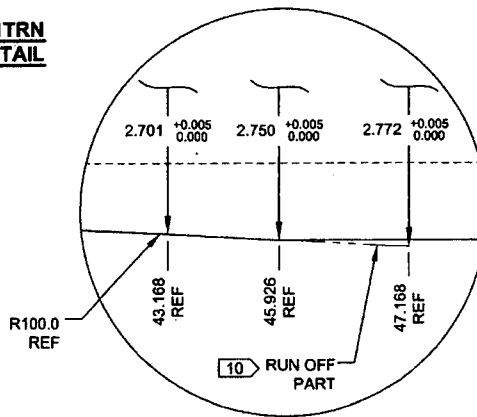
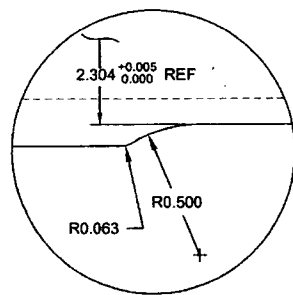
SECTION B-B
SCALE 4X

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2014-05-26

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DRAWN	<i>Q</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D212-664-141	SHEET 4 OF 5
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D212-664-141TRN
TURNING DETAIL



RELEASED
2014-05-26

DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	92	DRAWING NO.	REV. E
MFG. APPR.	92	D212-664-141	SHEET 5 OF 5
APPROVED	92	TITLE	SCALE
DE APPR.	92	XTUBE ASS'Y (205/212/412 HI FWD)	NTS
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2/2

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1



skyservice Work Order Traveler

Sky Service F.B.O. Inc.

Page: 1 of 2

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO21404	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: 24902
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN: 0	CSN: 0	TSO: 0	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT INSPECTION (LIQUID PENETRANT) ON 8 CROSSTUBES + 16 MISC PARTS

ITEM ID: D212-664-101 FWD CROSSTUBE - HIGH

1 - WORK ORDER ID#: 119978

2 - WORK ORDER ID#: 119980

3 - WORK ORDER ID#: 119981

4 - WORK ORDER ID#: 119982

5 - WORK ORDER ID#: 119977

6 - WORK ORDER ID#: 119540

7 - WORK ORDER ID#: 119975

8 - WORK ORDER ID#: 120017

DAS

27

8-89

14/7/8

ID#: D4803-1 STRUT

9 - WORK ORDER ID#: 116507 (QTY2)

ID#: D4837-1 STRUT

10 - WORK ORDER ID#: 116526 (QTY2)

ID#: D4801-1 STRUT

11 - WORK ORDER ID#: 116502 (QTY2)

ID#: D4834-1 STRUT

12 - WORK ORDER ID#: 116519 (QTY2)

ID#: D4801-2 STRUT

13 - WORK ORDER ID#: 116503 (QTY2)

ID#: D4802-1 STRUT

14 - WORK ORDER ID#: 117219 (QTY2)

ID#: D4834-2 STRUT

15 - WORK ORDER ID#: 116520 (QTY2)

ID#: D4836-1 STRUT

16 - WORK ORDER ID#: 116524 (QTY2)

Action Taken:	Date:	Initial/Stamp:
LIQUID PENETRANT INSPECTION CARRIED OUT ON ITEMS LISTED ABOVE (ITEMS 1-16) AS PER ASTM1417M-13 NO CRACK FOUND Pen: ZL-56 BATCH# 09H094 EXP. DATE: AUG 2014, DEV: SKD-S2 EXP. DATE: OCT2017 CLEANER: SKC-S EXP. DATE: APR 2018	JUL 08 2014	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp 177 53-89	Date: JUL 08 2014
Name: ANTONINO MARCHETTA		